

Date: Monday, 11/21/2005 11:57:30 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACER BUSHING
Job Number :	24873		
Estimate Number :	10823		
P.O. Number :	N/A	Part Number :	D23271
This Issue :	11/21/2005	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2327 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	N/A	Drawing Revision :	C
	Type :	Material :	N/A
	MACHINED PARTS	Due Date :	12/15/2005
Written By :	<u>See comment below</u>		Qty: 50 Um: Each
Checked & Approved By :	<u>See comment below</u>		
Comment :	Est. D 05.11.02 Removed 303 SS KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0750	Inventory
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60



Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)

Inventory

Material: AISI ³⁰³ ~~304~~ Round Bar Ø0.375"

(Max R0.375)

Batch: M16656 mf 05/11/23 50

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Debur

mf 05/11/23 50
mf 05/11/23 50

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf 05/11/23 50
05-11-23 50

4.0	QC8	SECOND CHECK <u>J.L</u>
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Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 31

C20511/23 50

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 05/11/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/21/2005 11:57:30 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 24873

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 05/11/24 (50) LSP 05/11/24/ (50)

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector




Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

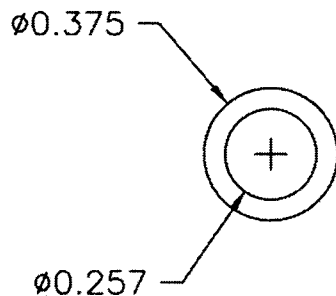
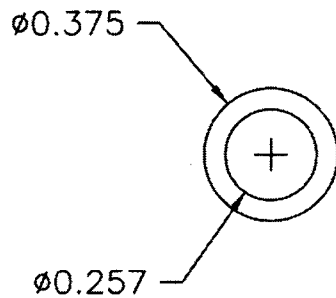
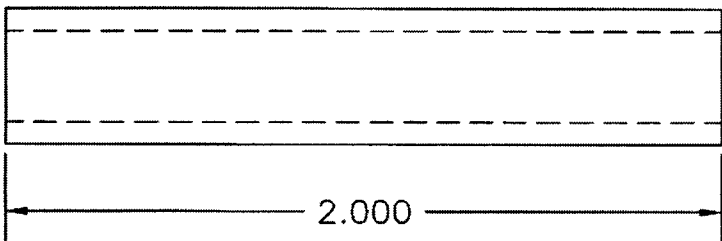
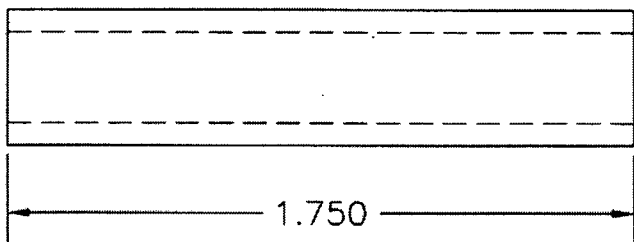
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW				HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D2327	SHEET 1 OF 1
DATE				TITLE	SCALE
03.05.13				SPACER BUSHING	2:1
A		94.12.17	NEW ISSUE		
B		95.12.06	LENGTH CHANGE		
C		03.05.13	303 SS SPEC ADDED		

RELEASED
03.05.21D2327-1D2327-3**NOTE:**

- 1) MATERIAL: $\phi 0.375$ AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR $\phi 0.375$ AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	:	0024873	Department Code:	
Project Name	:	D2327-1	Burden Flags	: NNNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2327-1	Invoice Number	:
Description	:	Spacer Bushing	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	50	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00